

Work Order ID 113493

February-19-14 8:40:05 AM

113493

RH

Page 1

Item ID: D119-646-241

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 2/19/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/05/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-02-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3887-045	C								
IIN-D119-646	B								

100

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D119-646-241

CHG003

DAS

S1

9-29

1 14-05-02

110

0.00

110

Skidtubes

Memo

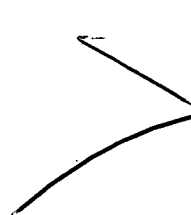
0.00

Skidtubes

1- inspect Mat'L D2500-1-190 for damage

2-Cut tube to length as per dwg D3887 (154.8")

3- Ensure squareness of ends and scribe batch#



DD

14-2-27

Work Order ID 113493

February-19-14 8:40:05 AM

113493

Page 2

Item ID: D119-646-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Stop ***NS2***Start Date: 2/19/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120 HandFinish Hand Finishing	Memo	0.00				1	0	14-3-3 JGC	
121	QC7-Inspect Chemical Conversion Coat	0.00							
121 QC Quality Control	Memo	0.00				1	0	14-03-04	DAS 18 8-83
122	QC5- Inspect part completeness to step on W/O	0.00							
122 QC Quality Control	Memo	0.00				1	0	14-03-04	DAS 18 8-83

Work Order ID 113493

February-19-14 8:40:05 AM

113493

Page 3

Item ID: D119-646-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 2/19/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

0.00

Skidtubes

Skidtubes

Memo

1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only.

2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes.

3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477

4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes***

5- Deburr, blow out chips from inside of tube.

6- Bond web in place as per Dwg D3887 & QSI 015.

A/RSikaflex-291 12/9/18Sikaflex expire date: 14-8-16Start: _____ Time: 2:40 pm

Finish: _____ Time: _____

***** (Adhere for 12 hours) *****

DGL 14-3-4

February-19-14 8:40:05 AM

1 13493

Page 4

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 2/19/14 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 3/05/14 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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135

QC5- Inspect part completeness to step on W/O

0.00

135

QC

Memo

0.00

Quality Control

14-3-5

Work Order ID 113493

February-19-14 8:40:05 AM

113493

Page 5

Item ID: D119-646-241 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)
Start Date: 2/19/14 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 3/05/14 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00

140

Skidtubes

Skidtubes

Memo

0.00

1- Bend FWD end of tube using bender 1 and bend prog. D3887.***Must use bending aid DT9544, ensure proper positioning***

2- Cut FWD end of tube as per dwg D3887.***Verify measurment***

3- Buff out marks left from bending

4- Drill FWD cap holes using DT8215. Do not open FWD & AFT cap holes to 0.208"

5- Open FWD saddle holes to finished size as per dwg D3887

6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size.(verify measurement)

7- Drill Tow ring hole, using DT9494 locate from FWD cap hole. (verify neasurement). Open to finished size.

8- Drill 1.87" and 3.74 holes using DT9494 locate from FWD cap hole. (verify measurement) as per dwg DEO D3887-B-1.

9- Open FWD and Aft cap holes to finish size as per dwg.

10- Deburr and blow out chips from inside of tube.

DP 14-3-5
BE 14-03-06
DP 14-3-7
BE 14-03-06
DP 14-3-7

Work Order ID 113493

February-19-14 8:40:05 AM

113493

Page 6

Item ID: D119-646-241 Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 2/19/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC5- Inspect part completeness to step on W/O

0.00

150

0.00

QC

Memo

Quality Control

160

0.00

160

0.00

Skidtubes

Memo

Skidtubes

1- Countersink crossbolt spacer holes, and prepare tube for welding, deburr.

2-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod

A/RAluminum Rod

3-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole.

4-Counterbore x-bolt spacer holes as per Dwg D3887.

5- C'sink FWD cap holes as per detail "C"

6- Deburr and blow out chips from inside of tube

DAS
27
9-49
14/3/10

BE14-03-11

BE14-03-11

DP 14-3-11

DP 14-3-12

Work Order ID 113493

February-19-14 8:40:05 AM

113493

Page 7

Item ID: D119-646-241 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)
 Start Date: 2/19/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/05/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							
170						①	14-03-12		DAS 9 9-89
QC	Memo	0.00							
Quality Control									
180	QC10- Inspect visual per QSI004- ground welds	0.00							
180						①	14-03-12		DAS 9 9-89
QC	Memo	0.00							
Quality Control									
190	Pressure Wash per QSI005 4.3	0.00							
190						1	76 14-3-15		
HandFinish	Memo	0.00				1	76 145-1		
Hand Finishing									

P70

DART AEROSPACE LTD		Work Order:	113493
Description: Repair Scheme D119-646-241 Skid tubes FWD GHW holes do not align NCR 14-3771 For tubes in production and Returned tubes			
Drawing: D3887	Repair Scheme:	RS1015	
Part No: D119-646-241	Page:	1 of 1	
Batch No:	Qty:	1	

Step	Location	Procedure	By	Date	Qty
1	Finishing	Remove FWD & AFT caps D2855-3. Clean all sikaflex off cap & identify per each tube caps was removed (P/N & B#)	N/A		
2	Skidtube	Drill out & remove FWD Cross bolt spacers D2579 in Detail C on Dwg D3887	DP	14-4-29	1
3	Skidtube	Reposition location of holes as per Drawing but using <u>+/-0.005" tol</u> and per symmetrical in QSI 018	DP	14-4-29	1
4	Skidtube	TACK ONLY Cross bolt spacers D2579 B <u>113785</u>	N/A		
5	QC	Location MUST be verified by QC Record Dims HERE 3.712 / 3.718" S -0.025 / -0.022" 14/04/30	N/A		
6	Skidtube	Weld as per QSI 004 A/R <u>M12B385</u> Back Drill Grind welds flush & deburr	BE	14-04-29	1
7	QC	QC 10 & 5 Inspection ***TEST FIT GHW WHEELS*** Pass <input checked="" type="checkbox"/>	DAS 16 9-89	14/04/30	
8	Finishing	Touch up alodine as per QSI 005			
9	Finishing	Touch up Powder coat per QSI 005	N/A		
10	Finishing	Re-assemble original caps back on tubes Sikaflex B _____ exp _____	See info		
11	QC	QC 3 inspect			
12	QC	QC 5 inspect			
13	QC	QC21			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.04.29	New Issue	ED		

U:\Admin\Forms\RepairschemblA.doc

Rev. A

Work Order ID 113493

February-19-14 8:40:05 AM

BA *113493*

Page 8

Item ID: D119-646-241 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)
 Start Date: 2/19/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/05/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M/28007</i> Memo START TIME: <i>7:10</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>8:10</i>	0.00 0.00				<i>1</i>	<i>0</i>	<i>4-5-2</i>	<i>DAS 34 9:00</i>
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>x 1 R H</i>	<i>f</i>	<i>90</i>	<i>14/05/02</i>
240 *240* HandFinish Hand Finishing	Hand Finishing Memo 1-Install wearplates as per Dwg D3887. 2-Inspect for foreign objects as per QSI 024 3-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 <i>14128763</i> Sikaflex expire date: <i>12/10</i>	0.00 0.00				<i>1 R H</i>	<i>f</i>	<i>90</i>	<i>14/05/02</i>

Work Order ID 113493

February-19-14 8:40:05 AM

113493

Page 9

Item ID: D119-646-241

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 2/19/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/05/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC5- Inspect part completeness to step on W/O

0.00

SPC
*14/5/12****250***

QC

Memo

0.00

Quality Control

255

Wing Walk as per dwg QSI005 4.4 Batch *111282003*

0.00

255

HandFinish

Memo

0.00

Hand Finishing

*1 RH of 911 14/05/10**SPC*
14/5/12

256

QC3- Inspect Part Finish

0.00

256

QC

Memo

0.00

Quality Control

Work Order ID 113493

February-19-14 8:40:05 AM

113493

Page 10

Item ID: D119-646-241 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 2/19/14 Start Qty: 1.00 *1*

Required Date: 3/05/14 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Identify as per dwg & Stock Location: _____	0.00							
260									
Packaging	Memo	0.00							
Packaging									
270	QC21- Final Inspection - Work Order Release	0.00							
270									
QC	Memo	0.00							
Quality Control									

MCS 14-05-02

H 14-05-02

Picklist Print

February-19-14 8:40:08 AM

Page 1

Work Order ID: 113493

113493

Parent Item: D119-646-241

D119-646-241

Parent Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 2/19/14

Required Date: 3/05/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20
per chg003 ECN13-534 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2500-1-190		Manufactured	No			110	Each	76.0000	1	1			
D2500-1-190													
Ext'n -T Beam Tube 4"													

Location	Loc Qty	Loc Code
HALL	76	
105279	75	
80061	1	

D2579		Manufactured	No			140	Each	11.0000	2	2			
D2579													
Crossbolt Spacer													

Location	Loc Qty	Loc Code
LG001	11	
105932	11	

D2855-3		Manufactured	No			240	Each	0.0000	2	2			
D2855-3													
Cap													

D3672-1		Manufactured	No			240	Each	1,346.000	2	2			
D3672-1													
Phenolic Washer													

Location	Loc Qty	Loc Code
FG	10	
85222	10	
ST060	1336	
103845	100	
112218	500	
93886	522	
99099	214	

Picklist Print

February-19-14 8:40:09 AM

Page 2

Work Order ID: 113493

113493

Parent Item: D119-646-241

D119-646-241

Parent Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 2/19/14

Required Date: 3/05/14

Start Qty: 1.00

Required Qty: 1.00

D3681-1 Manufactured No 160 Each 196.0000 8 8

D3681-1

Spacer

**

BE14-03-11

Location	Loc Qty	Loc Code
LG001	196	
108647	60	
109109	136	

D3849-041 Manufactured No 240 Each 0.0000 1 1

D3849-041

Fwd Wearplate Assy, Std/Float Gear

D3849-043

Manufactured No 240 Each 4.0000 1 1

D3849-043

Aft Wearplate Aay, Std Gear

**

B113742 (1x) 146/05/6

**

B102313 (1x) 146/03/02

Location	Loc Qty	Loc Code
FP002	4	
102313	4	

D3885-1 Manufactured No 140 Each 6.0000 1 1

D3885-1

Standard Web

**

Location	Loc Qty	Loc Code
LG002	6	
102267	5	
106418	1	

D3903-1 Manufactured No 160 Each 45.0000 12 12

D3903-1

Spacer

**

DGL 14-3-4

BE14-03-11
B112408 x3

Location	Loc Qty	Loc Code
LG001	45	
109112	45	

February-19-14 8:40:09 AM

Shop Packet Print

Page 2

Picklist Print

February-19-14 8:40:09 AM

Page 3

Work Order ID: 113493

113493

Parent Item: D119-646-241

D119-646-241

Parent Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 2/19/14

Required Date: 3/05/14

Start Qty: 1.00

Required Qty: 1.00

D3904-1

Manufactured No

240 Each 0.0000 16

D3904-1

Washer

B113080 X4 **

16
JL 14/05/102

AN3C5A

Purchased No

240 Each 1,705.000 2

AN3C5A

Bolt

B113662 X12
1,705.000

**

2
JL 14/05/102

Location

Loc Qty

Loc Code

FG

5

122800

5

ST350

1700

M128057

1700

✓2

AN3C46A

Purchased No

240 Each 65.0000 8

AN3C46A

Bolt

**

8
JL 14/05/102

Location

Loc Qty

Loc Code

FG

10

122843

10

ST353

53

M127823

53

ST354

2

M127281

2

X2

MS21043-3

Purchased No

240 Each 621.0000 8

MS21043-3

Nut

**

8
JL 14/05/102

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

541

124555

67

m126741

474

M1128398

X2

February-19-14 8:40:09 AM

Shop Packet Print

Page 3

Picklist Print

February-19-14 8:40:09 AM

Page 4

Work Order ID: 113493

113493

Parent Item: D119-646-241

D119-646-241

Parent Item Name: Replacement Skidtube with Run-On Wearplates (Fits LH or RH)

Start Date: 2/19/14

Required Date: 3/05/14

Start Qty: 1.00

Required Qty: 1.00

MS24694-C52

Purchased

No

Each

150.0000

2

MS24694-C52

? *

**

all 1403/10

SCREW

Location

Loc Qty

Loc Code

ST301

150

M126284

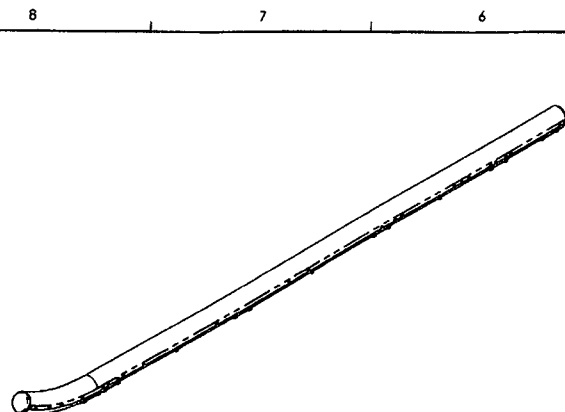
42

124308

50

m127059

100



D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3887-043 STANDARD SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-1 WEB
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3887-041 = 32.0 lbs
D3887-043 = 37.0 lbs
D3887-045 = 38.1 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) INSERT D3885-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO Ø0.197 HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8931 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPLATE INSERTS. INSTALL AELS-1032-130 INTO D3887-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3887-041	STD SKIDTUBE ASSY WITH WEARPAD
2		X		D3887-043	STD SKIDTUBE ASSY WITH WEARPLATE
3			X	D3887-045	STD SKIDTUBE ASSY WITH TRAINING WEARPLATE
10	2	2	2	D2579	CROSS BOLT SPACER
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	2	2	2	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	5			D3846-1	GASKET
16	1			D3846-11	GASKET
17	5	5		D3847-1	WEARPAD
18	1	1		D3847-11	AFT WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-047	AFT WEARPLATE ASSY
22			1	D3849-041	FWD TRAINING WEARPLATE ASSY
23			1	D3849-043	AFT WEARPLATE ASSY
24	1	1	1	D3885-1	STANDARD WEB
25	1	1		D3887-11	STANDARD SKIDTUBE
26			1	D3887-13	STANDARD SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
41	30	30		ALS4-1032-130	INSERT
42	32	32	2	AN3C5A	BOLT
43			8	AN3C46A	BOLT
44	32	32		NAS1149C0332R	WASHER (OR AN960C10L)
45			8	MS21043-3	NUT
46	2	2	2	MS24694-C52	SCREW

RELEASED
 2013-03-18

113493 MJS
 14-02-19

C	(SHT1, P/L, ZN C2-2, C3-2, C4-2) ITEM 13, QTY 2 WAS 4, ITEM 42, QTY 32 WAS 34, ITEM 44, QTY 30 WAS 32, ADD ITEM 46, MS24694-C52 WAS AN3C5A, 2 PLCS (ZN C1-5, C1-6, B4-7) Ø0.201 CSK Ø0.385 X 100" WAS Ø0.214 THRU, ADDED DETAIL F (ZN C8-5, C8-6, B8-7), ADD ITEM 10, D2579 CROSS BOLT SPACER (ZN D4-1, A6-7)	DB	13.02.19
B	ALS4-1032-130 WAS AELS-1032-130 (ZN C4-1, C6-7, C3-7); ADD DT8931 (ZN A6-1), ADD 134-04 (ZN C4-9), D2855-3 WAS D2575 (ZN D4-1, C7-2, C2-2, C7-3, C2-3, C7-4, C2-4); AN3C5A WAS AN3C4A (ZN C6-2, C2-2, C6-3, C2-3, C6-4, C2-4); Ø0.313 WAS Ø0.328 (ZN C4-5, C4-5, C2-7 & B3-7) REVISED NOTE N (ZN B3-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	MJS	DRAWING NO.	REV. C
MFG. APPR.	JS	D3887	SHEET 1 OF 8
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	A119 STD SKIDTUBE ASSY	NTS
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AN3C5A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

D3846-11
GASKET

D3847-11
WEARPAD

1.5
1.5

2.00 DISTANCE TO D3885-1 WEB, REF

AN3C5A BOLT
NAS1149C0332R WASHER
24 PL

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

11
Ø0.197
8 PL PER SIDE
REF

1.5
1.5
PLUG UNUSED INSERTS WITH
AN3C5A BOLT
NAS1149C0332R WASHER
6 PL

D3846-1
GASKET
5 PL

D3847-1
WEARPAD
5 PL

D2855-3 CAP

SEAL WITH
SIKAFLEX-241/291

MS24694-C52 SCREW
(1 PER SIDE)

D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD
(MAKE FROM D3887-11)

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WFO

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MFG. APPR.	DS	D3887	SHEET 2 OF 8
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AN3C5A BOLT
D3872-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

D3847-11
WEARPAD

D3847-047
AFT WEARPLATE ASSY

AN3C5A BOLT
NAS1149C0332R WASHER
30 PL

D3847-045
CENTER WEARPLATE ASSY

D3847-043
FWD WEARPLATE ASSY

D3847-1
WEARPAD
5 PL

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

11
Ø0.197
8 PL PER SIDE
REF

2.00 DISTANCE TO D3885-1 WEB, REF

D2855-3 CAP

SEAL WITH
SIKAFLEX-241/291

MS24694-C52 SCREW
(1 PER SIDE)

D3887-043 STANDARD SKIDTUBE ASSY WITH WEARPLATE
(MAKE FROM D3887-11)

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AN3C5A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

AN3C46A BOLT
D3904-1 WASHER, 2 PL
MS21043-3 NUT
8 PL

D3849-043
AFT TRAINING WEARPLATE ASSY

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

1.5 1.5 1.5 1.5

D3849-041
FWD TRAINING WEARPLATE ASSY

1.5 D2855-3 CAP

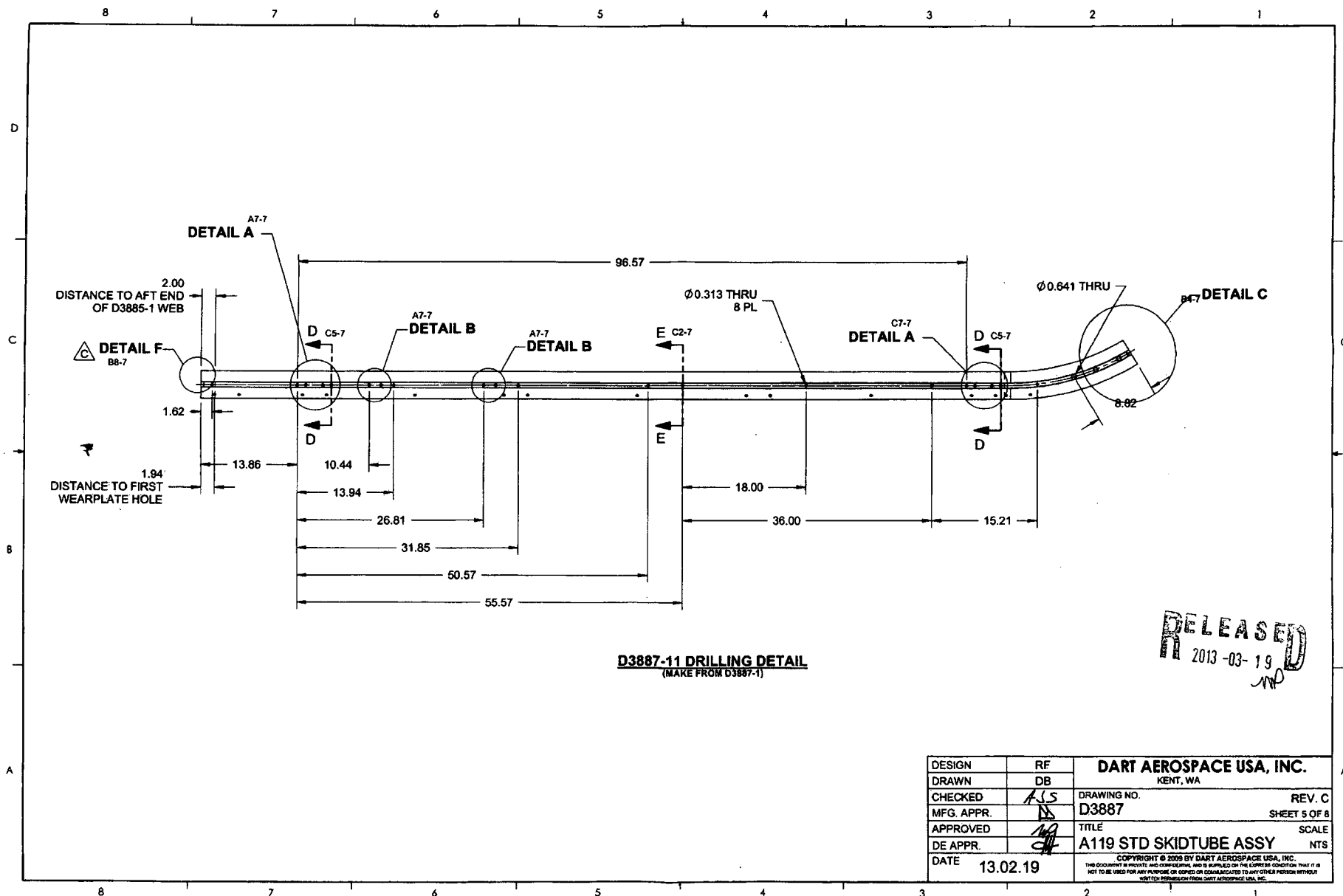
SEAL WITH
SIKAFLEX-241/291

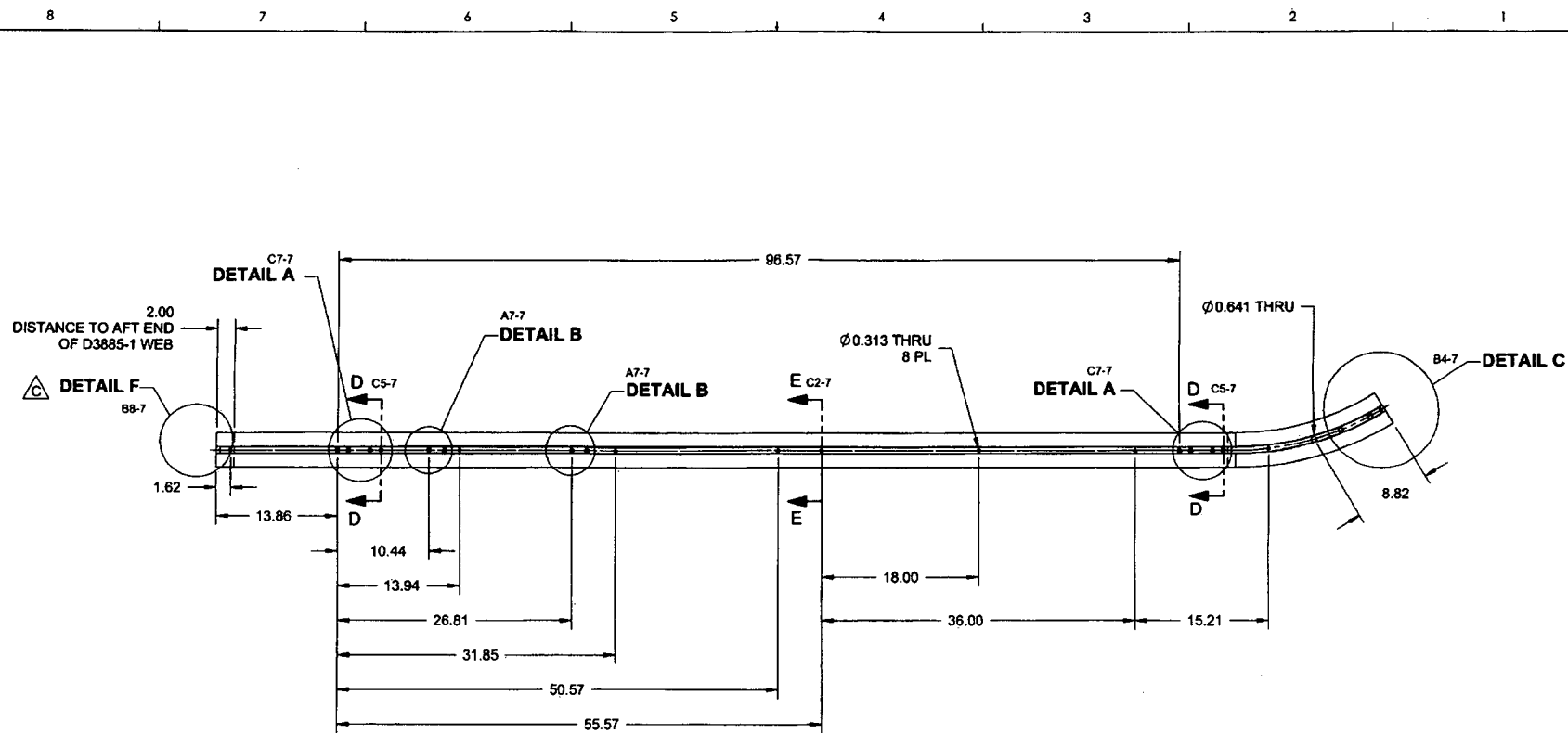
MS24694-C52 SCREW
(1 PER SIDE)

D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE
(MAKE FROM D3387-13)

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MFG. APPR.	N	D3887	SHEET 4 OF 8
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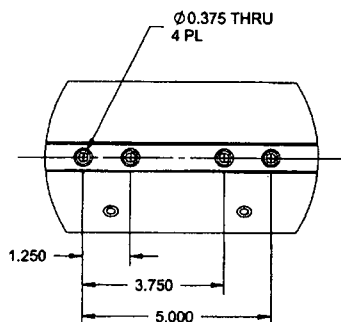




D3887-13 DRILLING DETAIL
(MAKE FROM D3887-1)

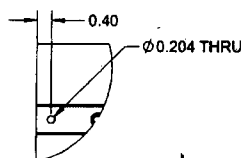
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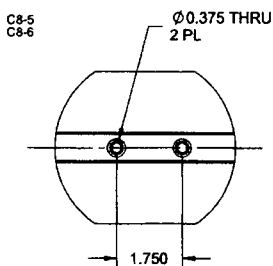


DETAIL A
SCALE 4X

D7-5
C3-5
D7-6
C3-6

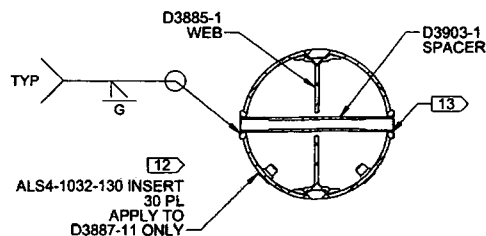


DETAIL F
SCALE 4X



DETAIL B
SCALE 4X

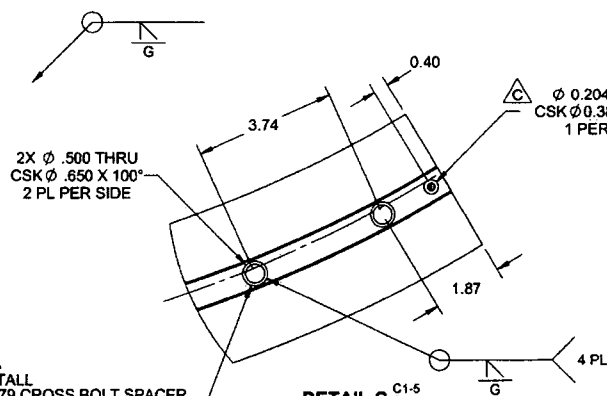
C8-5
C5-5
C8-6
C5-6



SECTION D-D
SCALE 4X

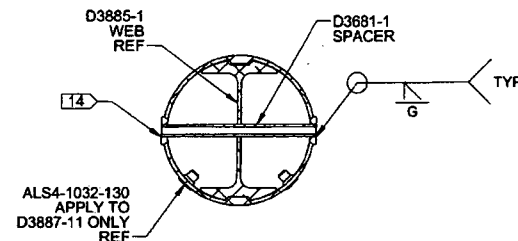
(FOR 12 X $\phi 0.375$ HOLES
PER SKIDTUBE)

C7-5
C3-5
C7-6
C2-6



DETAIL C
TYPICAL
SCALE 4X

C1-5
C1-6



SECTION E-E
SCALE 4X
(FOR 8 X $\phi 0.313$ HOLES
PER SKIDTUBE)

C4-5
C4-6

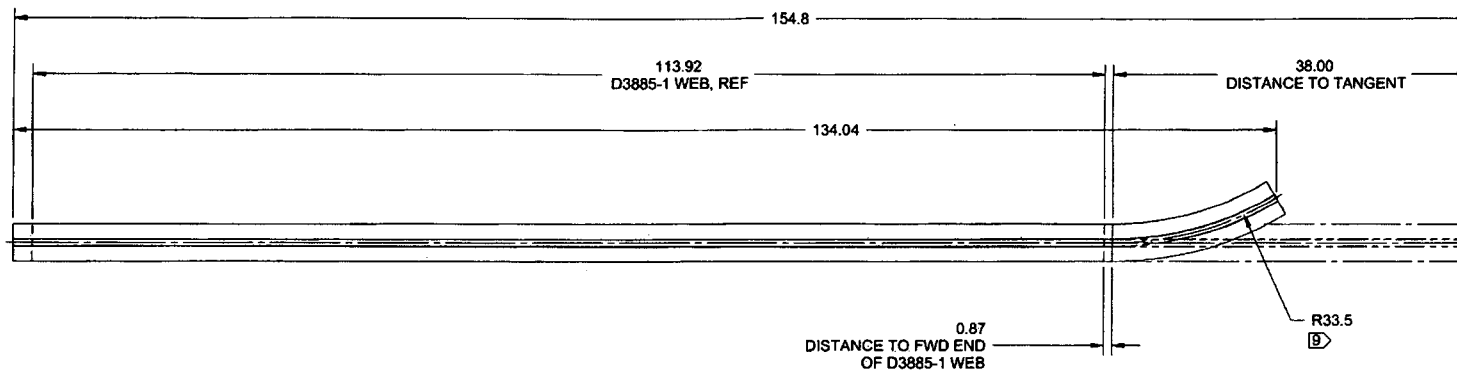
NOTES:

- 13) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.375$ HOLES ONLY:
i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
ii) INSERT D3903-1 SPACER
iii) WELD INTO PLACE AND GRIND FLUSH
iv) C'BORE TO 0.313×0.75 DEEP
v) DEBURR HOLES

- 14) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.313$ HOLES ONLY:
vi) CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
vii) INSERT D3681-1 SPACER
viii) WELD INTO PLACE AND GRIND FLUSH
ix) DEBURR HOLES

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D3887-1 BEND DETAIL
(MAKE FROM D2500-1-190 EXTRUSION)

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2013-03-19

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No. 342

**AWS D17.1/D17.1M:2010
SKIDTUBE WELDING TEST RECORD**

Name: Berclay Elliott
Job #: 112723
Part #: D117 646-243
Description: float tube
Welding Process: TIG [☒] MIG []
Base Material: Aluminium
Current: AC [☒] DC []

TEST REQUIREMENTS AND RESULTS

Visual:	pass [<input checked="" type="checkbox"/>] fail []
Penetration:	pass [<input checked="" type="checkbox"/>] fail []
Fusion:	pass [<input checked="" type="checkbox"/>] fail []
Cracks:	pass [<input checked="" type="checkbox"/>] fail []
Overlap (cold lap)	pass [<input checked="" type="checkbox"/>] fail []
Undercut:	pass [<input checked="" type="checkbox"/>] fail []
Pin holes:	pass [<input checked="" type="checkbox"/>] fail []
Porosity (surface):	pass [<input checked="" type="checkbox"/>] fail []
Coloration:	pass [<input checked="" type="checkbox"/>] fail []
Burn through:	pass [<input checked="" type="checkbox"/>] fail []

342
9
2-88

Qualifier: _____

Date of Test Coupon: 14-03-06

Welder: Berclay Elliott

Date of Test Coupon: 14-03-06

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.